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RB KIT 407M-15
Job Sheet 200561



Part No: RB KIT 407M-15

Job Qty: 12 pcs

Part Name: Gauge Pin .1200" dia.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Created By: Chantal Lavoie

Due Date: 10/7/19

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
90	Purchasing SEP 12 2019 DAS 13 9-89 PO H1304488	12 pcs	10/7/19	10/7/19	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	
95	Packaging 2-1 - Receive - B4B	12 pcs	10/7/19	10/7/19	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B	

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[Dart Hawkesbury] Job Sheet - Lavoie, Chantal

100 QC 6	12 pcs	10/7/19	0.00 0.00	Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
110 Small Fab - 2 - B4B	12 pcs	10/7/19	0.00 2.40	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
120 QC 5	12 pcs	10/7/19	0.00 0.00	Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
130 Packaging 3-1 - Stock - B4B	12 pcs	10/7/19	0.00 0.00	QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

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GP 19-11-18

DAS
31
3-89

NOV 27 2019

GP 19-11-28

GA90

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	12 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-50

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Part Op 90 - (Purchasing)
 Descriptions: 95 - (Receive & Inspect for Damage & Mat'l Certs)
 100 - (QC6- All purchased or subcontracted products)
 110 - 1-Cut pin in half, 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion.
 4-Package as per note 10.
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
21135A54	Plug Gauge	6 Ea (.5 ea)	90-Purchasing	210892

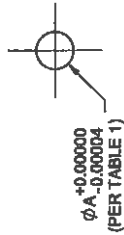
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	21135A54	6	71	0

Part Specifications

Specifications could not be found.

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**TABLE 1
GAUGE PIN DIMENSIONS**

PART NUMBER	ϕA	B	PURCHASE PART NUMBER (MCMASTER CARR)
RB KIT 407M-01	$\phi 0.2400$	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	$\phi 0.4000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	$\phi 0.5400$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	$\phi 0.6800$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	$\phi 0.8000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	$\phi 0.9600$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	$\phi 1.0800$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	$\phi 1.2000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	$\phi 1.4400$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	$\phi 1.4400$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	$\phi 1.6000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-23	$\phi 1.6000$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	$\phi 1.7280$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	$\phi 1.7280$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	$\phi 1.8000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	$\phi 1.9200$	1.00"	21135A55 OR EQUIV.

RB KIT 407M-01 THRU -31 ϕ .XXXX. CLASS X PLUG NO-GO GAUGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20030

NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	REV. D
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 9
CHECKED	KPT	TOOL PART #	SCALE
MFG. APPR.	DP	RB KIT 407M	NTS
APPROVED	VP	TITLE	
DATE	1/17/2019	SPLINE MEASURING KIT	

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